

Date: Tuesday, 02/12/2008 10:02:15 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 02.250 SUPPORT
Job Number : 43880	
Estimate Number : 11057	
P.O. Number :	Part Number : D28911
This Issue : 02/12/2008 S.O. No. :	Drawing Number : D2891 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A1
Previous Run : 43383	Material :
Written By :	Due Date : 09/12/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JUD 08.12.02</u>	
Comment : Est. C 02.11.26 Added P/O KJ	
Est D 08.03.19 Re-format: EC verified: DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DSK076	D2891-1 TURNING DETAIL
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Comment: Qty.: 0.5000 Each(s)/Unit Total : 10.0000 Each(s)

D2891-1 TURNING DETAIL

Batch: B 43868

JTP 09/01/05

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS

Machine as per Folio FA046

Tumble & Deburr

J.L / JTP 08/09/01/05

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.L / JTP 09/01/05

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 09/01/05

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 10:15

OVEN TEMPERATURE: 400

FINISH TIME: 10:45

M-L 09/01/09

(20X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 02/12/2008 10:02:15 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.250 SUPPORT

Job Number: 43880

Part Number: D28911

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-09-01

(20x)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Xtyle assy

85 09-01-13

(x20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43880	
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891		Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AB	0.240	0.260		0.251	0.2485	0.247	0.250	0.252
AC	0.115	0.150		0.124	0.124	0.123	0.124	0.124
AD	0.040	0.060		0.055	0.055	0.055	0.055	0.055
AE	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310		0.295	0.295	0.295	0.295	0.295
AH	0.115	0.150		0.138	0.138	0.137	0.137	0.137
AI	0.454	0.474		0.459	0.458	0.459	0.459	0.454
AJ	2.779	2.789		2.781	2.781	2.782	2.782	2.784
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.037	1.036	1.033	1.033	1.039
AM	0.053	0.073		0.062	0.062	0.062	0.062	0.062
AN	0.257	0.262		0.262	0.262	0.262	0.262	0.262
AO	1.663	1.683		1.670	1.670	1.670	1.670	1.671
AP	0.053	0.073		0.062	0.062	0.062	0.062	0.062
AQ	0.022	0.042		0.032	0.032	0.032	0.035	0.032
AR								
AS								
AT								
Accept/Reject				✓	✓			

Measured by: JIP / J.L	Date: 09/01/05
Audited by: SA 07/01/08	Date:
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43880
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	10
HAAS Section								
AA	0.188	0.193		.188	.188	.188	.189	.189
AB	0.240	0.260		.250	.246	.253	.245	.251
AC	0.115	0.150		.124	.125	.124	.124	.124
AD	0.040	0.060		.053	.059	.058	.054	.050
AE	0.010	0.020		.015	.015	.015	.015	.015
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.295	.295	.295	.295	.295
AH	0.115	0.150		.137	.137	.137	.137	.137
AI	0.454	0.474		.455	.454	.454	.460	.460
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.030	1.040	1.033	1.033	1.035
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.262	.262	.262	.262	.262
AO	1.663	1.683		1.671	1.672	1.671	1.672	1.672
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: J.L.	Date: 09/01/06
Audited by: S.A.	Date: 09/01/08
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43880
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	0.188	0.193		.189	.189	.189	.189	.189
AB	0.240	0.260		.252	.252	.250	.250	.252
AC	0.115	0.150		.124	.124	.124	.124	.124
AD	0.040	0.060		.048	.050	.053	.051	.050
AE	0.010	0.020		.015	.015	.015	.015	.015
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.295	.295	.295	.295	.295
AH	0.115	0.150		.137	.137	.137	.137	.137
AI	0.454	0.474		.465	.464	.462	.463	.464
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.035	1.035	1.030	1.035	1.036
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.260	.260	.260	.260	.260
AO	1.663	1.683		1.673	1.674	1.671	1.671	1.672
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: J.L	Date: 09/01/06
Audited by: J.D	Date: 09/01/08
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 143280
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	217	318	419	520
HAAS Section								
AA	0.188	0.193		.189	.189	.189	.189	.189
AB	0.240	0.260		.250	.248	.250	.248	.249
AC	0.115	0.150		.125	.124	.124	.125	.125
AD	0.040	0.060		.052	.050	.048	.050	.049
AE	0.010	0.020		.015	.015	.015	.015	.015
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.295	.295	.295	.295	.295
AH	0.115	0.150		.137	.138	.137	.138	.138
AI	0.454	0.474		.463	.462	.462	.464	.464
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.033	1.034	1.034	1.036	1.033
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.259	.259	.259	.259	.259
AO	1.663	1.683		1.672	1.673	1.672	1.674	1.675
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: JL **Date:** 09/01/06

Audited by: SA **Date:** 09/01/06

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

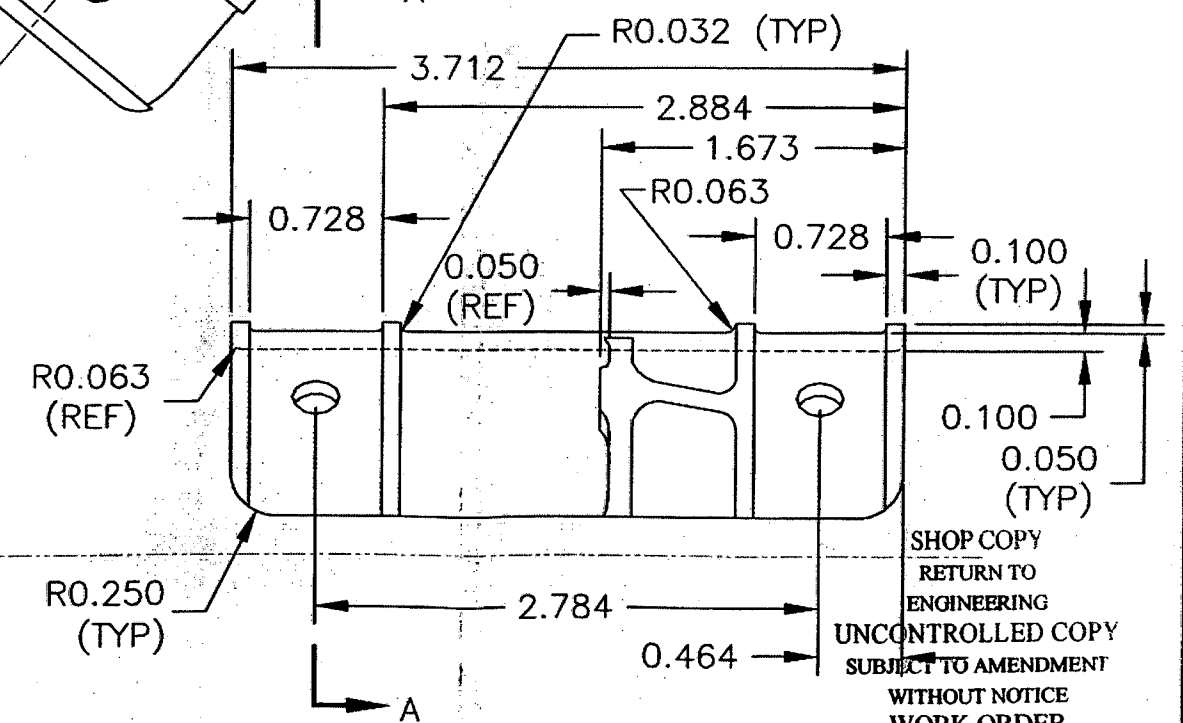
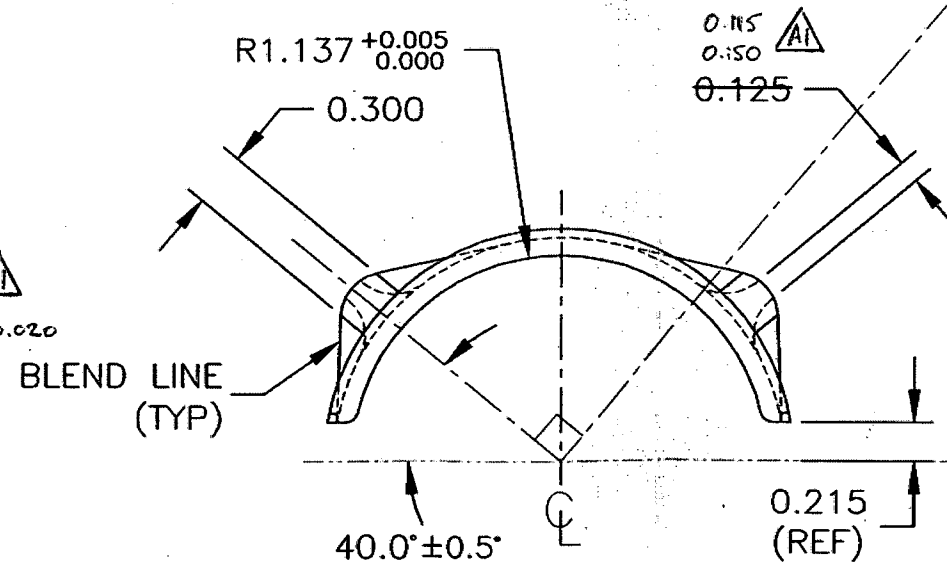
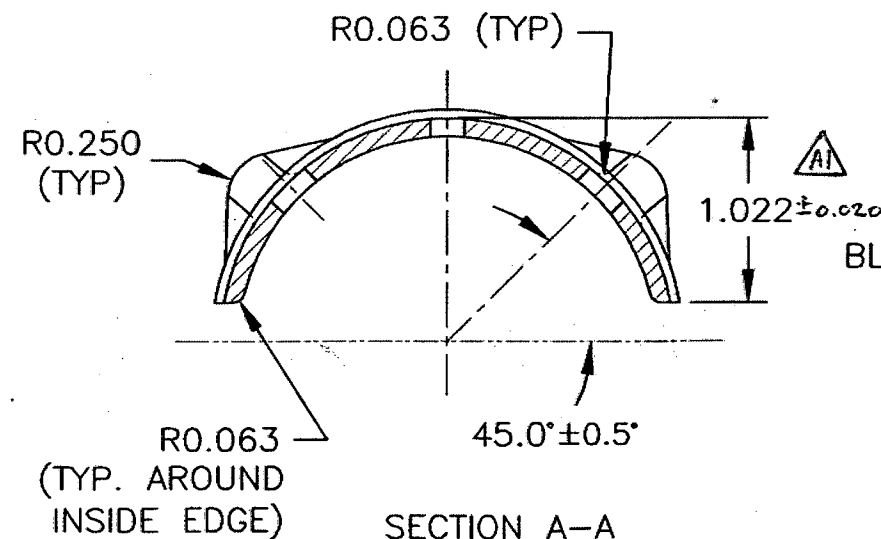
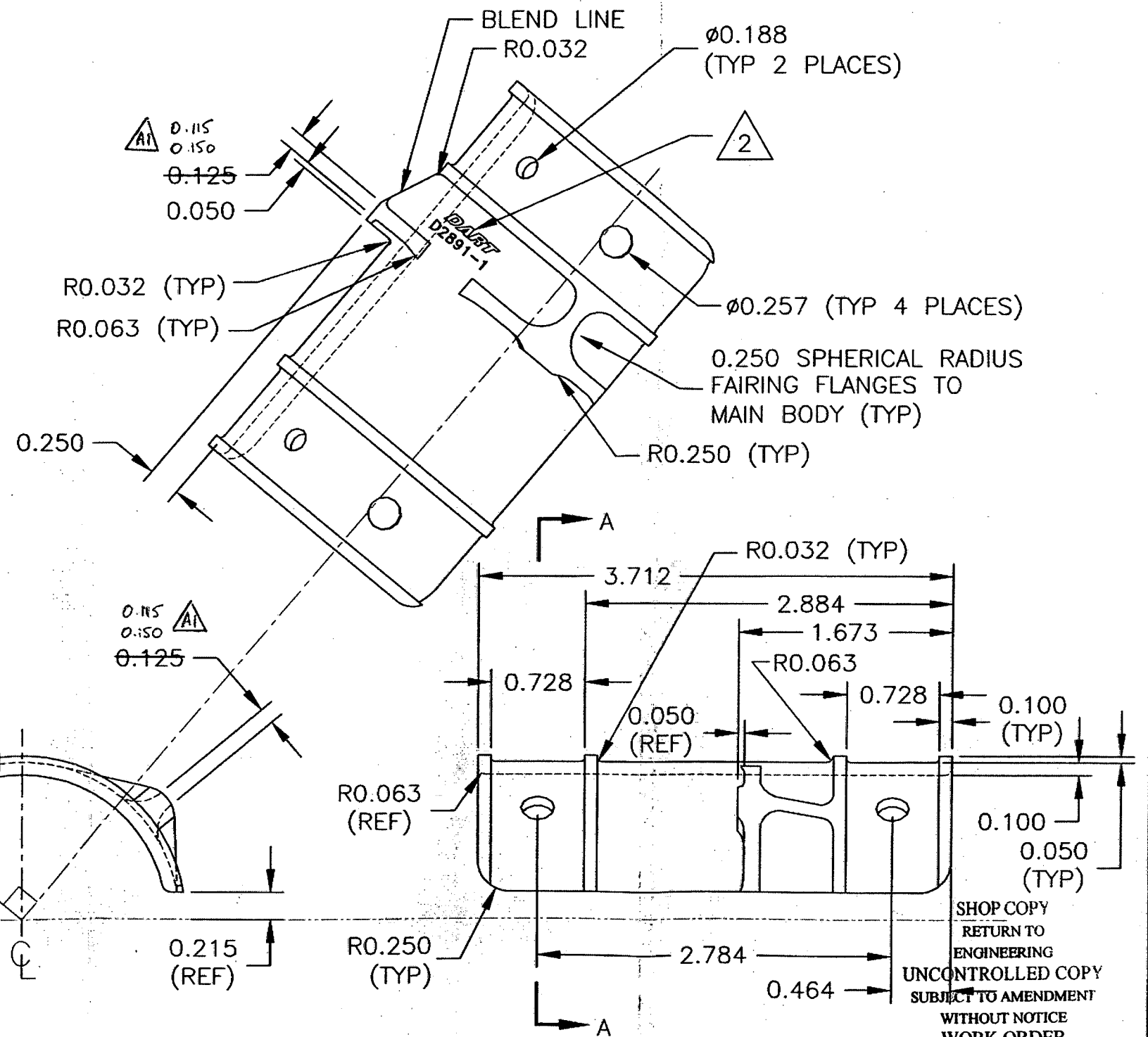
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2891-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP.
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43880

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DART AEROSPACE LTD.

AI	CP 02.01.23	UPDATE DIMS AS MANUFACTURED.
A	00.11.17	NEW ISSUE
DESIGN	CP	DART
CHECKED	CP	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DATE	00.11.17	DRAWING NO. D2891
		TITLE 02.250 SUPPORT
		REV. A
		SHEET 1 OF 1
		SCALE 1:1

